

Date: Friday, 20/02/2009 9:15:18 AM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	45922				
Estimate Number	10531				
P.O. Number		Part Number	D2572		
This Issue	20/02/2009	S.O. No.	D2572 REV E		
Prsht Rev.	NC		Project Number	N/A	
First Issue	/ /	Type	MACHINED PARTS		E
Previous Run	43565		Material		
Written By	<i>JL 09-02-20</i>		Due Date	27/02/2009	Qty: 12 Um: Each
Checked & Approved By					
Comment	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ				

Additional Product

Job Number:					
Seq. #:	Machine Or Operation:	Description:			
1.0	D6101005	Saddle Billet 			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <i>B34874</i> <i>mmf 09/02/20</i>					
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 			
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <i>1004</i> Double check by: <i>DSF</i> <i>B45922</i> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <i>mmf 09/02/24 88 09/02/21</i>					
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 			
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 <i>mmf 09/02/24 89 09/02/23</i>					
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>mmf 09/02/24 89 09/02/22</i>					

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 45922

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 09/02/09

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 09-02-26

(12)

7.0 POWDER COATING POWDER COATING



m1039996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 7:45

OVEN TEMPERATURE: 320°

FINISH TIME: 8:15

FL 09/03/09

(12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



HL

09-03-09

(12)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



10X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: U33

9/3/09

Se

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/03/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WTF
09-03-09

DART AEROSPACE LTD	Work Order:	45922
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.490	.490	.491	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.503	.503	.505	.497		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.571	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.499	1.500	1.500	1.500		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.124	.120	.120	.130		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.245	.241	.243	.248		
S	0.115	0.135		.126	.120	.120	.123		
T	0.178	0.198		.188	.188	.188	.183		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		.241	.235	.233	.238		
W	0.115	0.135		.130	.130	.125	.125		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.383	1.380	1.389	1.385		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.247	.247	.250	.250		
AH	0.240	0.260		.253	.250	.250	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JP	Audited by:	JL
Date:	07/02/21	Date:	09/02/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JP JLM

DART AEROSPACE LTD	Work Order:	45922
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 X	6 X	7 X	8 X	By	Date
A	0.438	0.443		.438	.438	.428	.438		
B	1.745	1.755		1.750	1.746	1.746	1.746		
C	3.495	3.505		3.500	3.496	3.496	3.496		
D	1.745	1.755		1.750	1.746	1.746	1.746		
E	7.990	8.010		8.000	7.994	8.000	8.000		
F	0.490	0.510		.500	.497	.504	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.503	.500	.503	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.568	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.253	.255	.253	.253		
S	0.115	0.135		.127	.134	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.962	2.962	2.963		
V	0.230	0.250		.240	.250	.245	.246		
W	0.115	0.135		.125	.125	.127	.124		
X	0.307	0.312		.310	.312	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.629	.626	.629		
AC	0.053	0.073		.060	.060	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.390	1.385	1.385		
AF	0.115	0.135		.125	.125	.130	.125		
AG	0.240	0.280		.250	.260	.260	.260		
AH	0.240	0.260		.250	.260	.255	.256		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.037	.033		

Accept/Reject

Measured by:	SS	Audited by:	J-L
Date:	09/02/23	Date:	09/02/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	Jeff JLM

DART AEROSPACE LTD

Work Order:

45922

Description: Saddle, Fwd Inboard

Part Number:

D2572

Inspection Dwg: D2572 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.439	.439	.440		
B	1.745	1.755		1.747	1.747	1.748	1.747		
C	3.495	3.505		3.499	3.500	3.505	3.502		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		7.998	8.000	8.000	7.997		
F	0.490	0.510		.509	.508	.510	.510		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.375	.376	.375	.375		
I	0.490	0.510		.503	.504	.507	.500		
J	1.174	1.184		1.179	1.179	1.178	1.173		
K	0.558	0.578		.573	.573	.575	.573		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.494	1.496		
N	2.495	2.505		2.500	2.499	2.500	2.499		
O	3.869	3.879		3.870	3.874	3.870	3.871		
P	0.115	0.135		.129	.126	.125	.127		
Q	0.115	0.135		.130	.130	.129	.130		
R	0.240	0.260		.255	.255	.256	.254		
S	0.115	0.135		.126	.126	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.920	2.960	2.959	2.961		
V	0.230	0.250		.250	.247	.243	.245		
W	0.115	0.135		.126	.121	.125	.125		
X	0.307	0.312		.310	.312	.312	.312		
Y	0.760	0.765		.762	.760	.760	.761		
Z	0.352	0.372		.360	.362	.363	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.629	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.386	1.385		
AF	0.115	0.135		.135	.130	.133	.130		
AG	0.240	0.280		.245	.255	.246	.250		
AH	0.240	0.260		.260	.255	.256	.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.038	.035	.035	.030		
Accept/Reject									

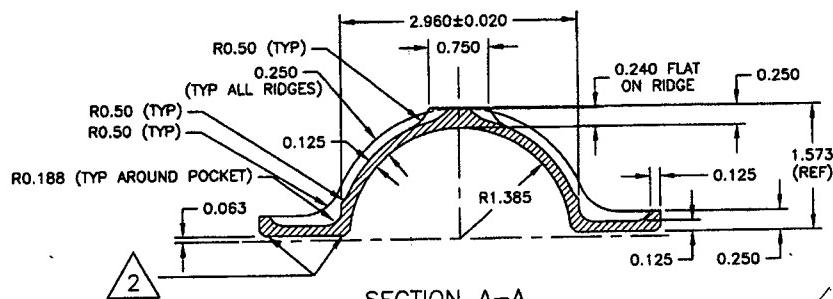
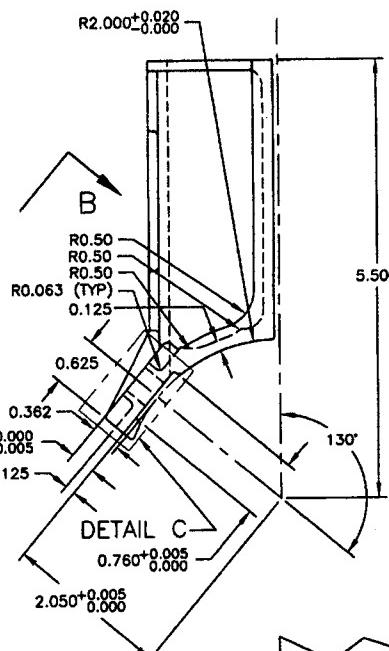
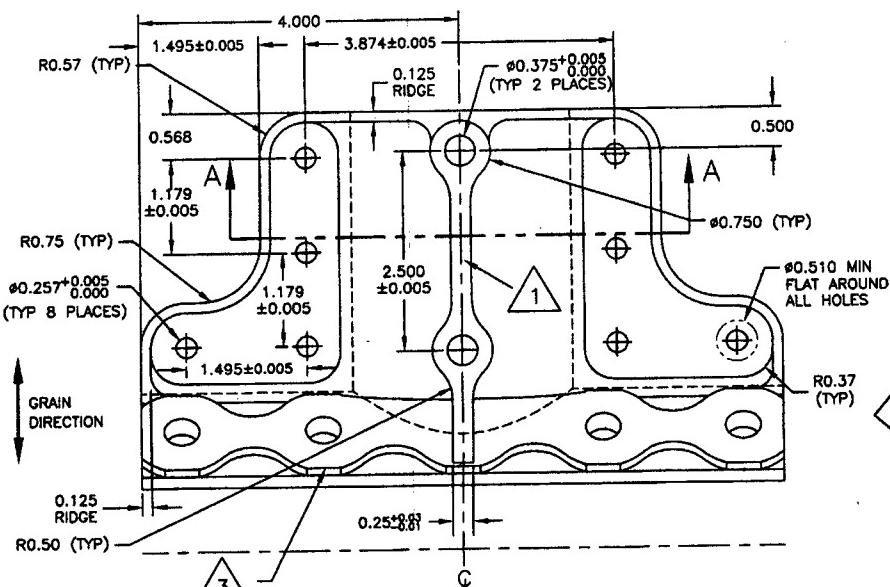
Measured by: ME
 Date: 09/02/25

Audited by: JL
 Date: 09/02/26

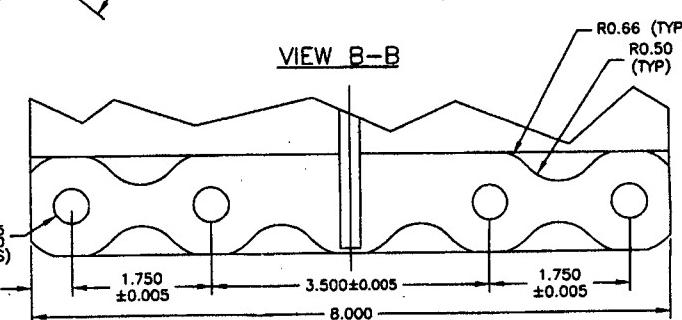
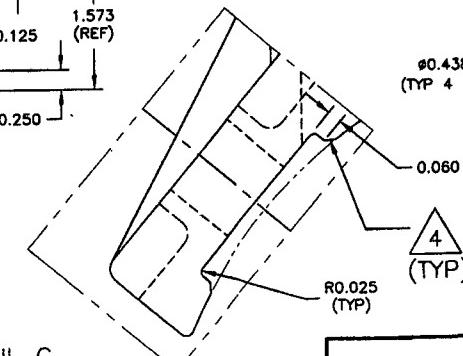
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <u>JL</u> <u>SD</u>	

RELEASED

05.12.06 -



DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN DS DRAWN BY PH DART DART AEROSPACE LTD.
CHECKED APPROVED DRAWING NO. D2572 REV. E
DATE 05.07.13 TITLE INNER FWD SADDLE SHEET 1 OF 1
SCALE 2:3

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2008/07/03